

Date: Thursday, 12/13/2007 11:14:57 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VALVE ASSEMBLY (1/2")
Job Number	: 36284		
Estimate Number	: 10727		
P.O. Number	: <u>N/A</u>	Part Number	: D200108
This Issue	: 12/13/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2001 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 34274	Material	: <u>N/A</u>
Written By	:	Due Date	: 12/19/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>4/07.12.13</u>		
Comment	: Est. C 03.04.11 Reformat KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5279  
 Order Apollo 76-10301 valve Ø0.5"  
 Possible Supplier: Flow Control  
 Material release note is required

C207112113

(10)

2.0	7610301	VALVE
-----	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 VALVE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage  
 Ensure Material Release Note is attached

LC 7/12/28

(10)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2001  
 Discard handle, retain nut

5 08/01/10

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Remove existing ID numbers on valve and replace with Dart part number and batch number

mf08-01-15

(10)

08/01/14

10

08/01/14

10

5.1 mach mat. that will collect  
P.F. PER ATTACHED DWG.

13 08.01.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 01/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:14:57 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE ASSEMBLY (1/2")

Job Number: 36284

Part Number: D200108

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



02/01/15



Comment: INSPECT WORK TO CURRENT STEP

AS 08/01/15 (x10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST2

AS 08/01/15 (x10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/16 (10)

Job Completion



u 08/01/16

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

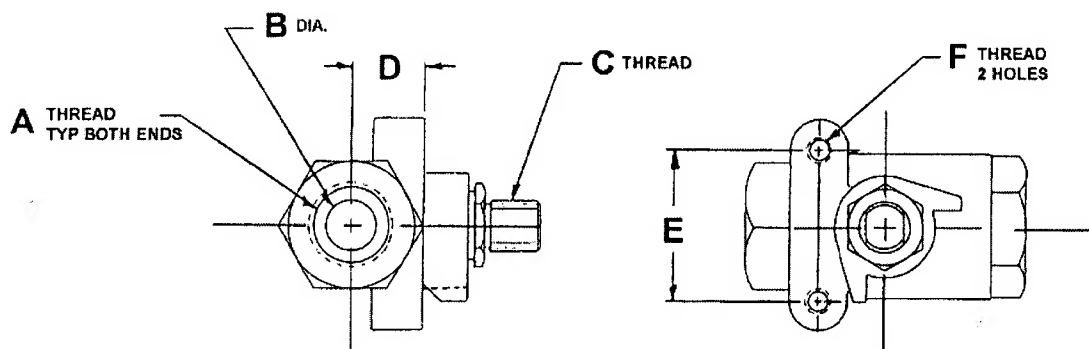
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2001	REV. C SHEET 1 OF 1
DATE 04.07.06		TITLE VALVE ASSEMBLY	SCALE NTS
-	90.04.02	NEW ISSUE	
A	92.05.12	-043 ADDED	
B	96.04.10	DART P/N CHG,041-6,042-12,ADD -16	
C	04.07.06	ADD D2001-4	

RELEASED  
04.07.09

## SPECIFICATION CONTROL DRAWING



Dart P/N	Apollo P/N	A	B	C	D	E	F
D2001-4	76-101-32	1/4 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-6	76-102-01	3/8 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-8	76-103-01	1/2 NPT	0.500	3/8-24 NF	0.60	1.120	10-24 UNC
D2001-12	76-104-01	3/4 NPT	0.680	7/16-20 NF	0.79	1.370	10-24 UNC
D2001-16	76-105-01	1 NPT	0.870	7/16-20	0.99	1.370	10-24 UNC

### NOTES:

- 1) POSSIBLE SUPPLIER: FLO-CONTROL INC. OR APOLLO VALVE DIVISION
- 2) DISCARD HANDLE AND ATTACHING NUT, EXCEPT FOR D2001-4
- 3) CHECK DIMENSION SHOWN ON THIS DRAWING
- 4) REFERENCE INFORMATION:

MATERIAL: 316 STAINLESS STEEL  
INVESTMENT CAST COMPONENTS  
MEETS NACE-MR-01-75  
MEETS WW-V-35C TYPE II, COMP SS, STYLE 3  
PRESSURE RATING: 2000 PSI @ 100°F  
150 PSI @ 400°F

- 5) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30284

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## Commercial Invoice

ACI-028229830036447

ECI

Invoice Number	Purpose of Shipment	Curr	Ult Dest.
Export Dt	C.I. References	USD	CA
12/19/2007	5005119059	Pkgs	Bill T/C
		1	1517-9324-0
		BOX	

Shipper:  
Debbie Sims  
Conbraco Industries  
1418 S Pearl St

Pageland  
SC 29728 US (843) 672-6161  
ID/EIN: 561345109

Broker

Consignee:

DART AEROSPACE  
MAIN FINISHED GOODS LOC  
1270 ABERDEEN ST  
HAWKS BURY  
ON K6A1K7 CA (770) 382-0006  
ID/EIN: 6

Importer

DART AEROSPACE  
MAIN FINISHED GOODS LOC  
1270 ABERDEEN ST  
HAWKS BURY  
ON K6A1K7 CA (770) 382-0006  
ID/EIN:

Non-Resident Importer: N

Part Nbr:	Marks/Nbrs :	Cntry MFG: US	Net Wgt:	0.0	lbs
HS Code:	Unit Qty:	10.00 EA	Unit Value:	28.210000	Commodity Value:
Desc: Stainless Steel Ball Valves					282.10

Total Shipment Weight:	0.0	Total Commodity Value:	282.10
These commodities, technology, or software were exported from the		Terms of Sale:	FCA/FOB
United States in accordance with the Export Administration Regulations.		Freight:	0.00
Diversion contrary to United States law is prohibited.		Insurance:	0.00
		Other:	0.00
		Total Invoice Value:	282.10

Comments:

1)  
2)  
3)

I declare all information in this invoice to be true and correct.

Signature of Shipper: Debbie Sims 12/19/2007

Tracking Numbers: 028229830036447



**Purchase Order**

Date Dec 13, 2007	Page 1
Purchase Order Number PO00005279	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FAKED**  
657/12/11

**Vendor Address:**

Flo-Control Inc.  
80 Center Rd.  
Cartersville, GA 30121  
Phone (770) 382-0006  
Fax (770) 382-0161

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-FL0001	Dec 13, 2007	N30	Fedex	Dec 21, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
10.0000	7610301 ✓	VALVE Comments: APOLLO P/N; 76-10301 VALVE 00.5" AS PER DWG D2001 REV. C	12/21/2007	No	49.729711	Each	497.30
<div>CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY</div>							

**Comments:**

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

**Tax Summary:**

Entered By: *CL* CLAVOIE

Approved By: *[Signature]*

Less: included tax	0.00
Subtotal	497.30
Total tax	0.00
Total purchase order in USD Dollars	497.30

## REFERENCE ONLY

FLO-CONTROL, INC.  
80 CENTER RD  
CARTERSVILLE, GA 30121

770-382-0006

INV DATE INV NO. Pg.  
12/26/07 66312 1

TERMS: NET 30 DAY  
DUE DATE: 01/25/08

RECEIVED DEC 28 2007

## BILL TO:

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ONT, CA K6A1K7

## SHIP TO:

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ONT CANADA K6A 1K7

NO.	ORDER DATE	CUSTOMER NO.	SRF	P.O. NO.	SHIP DATE	SHIP VIA
59393	12/13/07	204700	5	P000005279	12/19/07	FEDERAL EXPRESS
QTY ORDERED	ITEM	ITEM NO.	ITEM DESCRIPTION		UNIT	UNIT PRICE
QTY SHIPPED	UNIT	QTY BACKORDER			DISC %	EXTD PRICE
10	EACH	76-103-01	1/2" SS VALVE THREADED W/ EACH			49.73
10		0	MOUNTING PADS		0.00	497.30

SALES AMOUNT: 497.30  
MISC. AMOUNT: 0.00  
FREIGHT AMOUNT: 0.00  
TOTAL TAX AMOUNT: 0.00  
NET ORDER AMOUNT: 497.30  
CASH RECEIVED: 0.00  
BALANCE DUE: 497.30

**Marc Bellavance**

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**From:** Roberto Fuentes [rfuentes@dartaero.com]  
**Sent:** January 9, 2008 11:23 AM  
**To:** 'Marc Bellavance'  
**Cc:** David Shepherd  
**Subject:** RE: D2001

Hi Marc,

David and I found no problem with this modification manufacture need to do, but we suggest this modification need to reflect in the drawing as an option since this is inconsistent problem.

Roberto

---

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** Wednesday, January 09, 2008 7:28 AM  
**To:** 'Roberto Fuentes'  
**Subject:** RE: D2001

See pictures attached.

Thanks!

**Marc Bellavance**  
**Mechanical Designer/Technical Support**

***DART aerospace Ltd.***

Tel: 613-632-5200 Ext. 240  
Fax: 613-632-9311  
E-mail: [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)  
Web: [www.dartaero.com](http://www.dartaero.com)

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**From:** Roberto Fuentes [mailto:rfuentes@dartaero.com]  
**Sent:** January 8, 2008 5:13 PM  
**To:** 'Marc Bellavance'  
**Subject:** RE: D2001

Hi Marc,

I got both e-mail. Send me the picture of the interference when you have a chance.

Roberto

---

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** Tuesday, January 08, 2008 12:45 PM  
**To:** 'Fuentes, Roberto'  
**Subject:** FW: D2001  
**Importance:** High

Roberto,

09/01/2008



I don't know if you had a chance to reply to the e-mail below.

I just found out (thanks to David) that when George changed my computer, my e-mail address was not setup properly ([mbellanance@dartaero.com](mailto:mbellanance@dartaero.com) in stead of [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)). Can you please resend your response at the correct e-mail address by replying to this e-mail?

Thanks and sorry for the inconvenience.

**Marc Bellavance**  
**Mechanical Designer/Technical Support**

***DART aerospace Ltd.***

Tel: 613-632-5200 Ext. 240

Fax: 613-632-9311

E-mail: [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)

Web: [www.dartaero.com](http://www.dartaero.com)

---

**From:** Marc Bellavance [<mailto:mbellanance@dartaero.com>]

**Sent:** January 8, 2008 11:07 AM

**To:** 'Fuentes, Roberto'

**Subject:** D2001

Hi Roberto,

Please take a look at the attached drawing.

QC reported that the orientation of the left hexagonal fitting press fitted into the valve housing is inconsistent. Results, when trying to assemble the valve on the heater, there is some interference. They are asking if the parts would be acceptable if machined down as indicated per the provided sketches. I don't see a problem with that. Do you?

**Marc Bellavance**  
**Mechanical Designer/Technical Support**

***DART aerospace Ltd.***

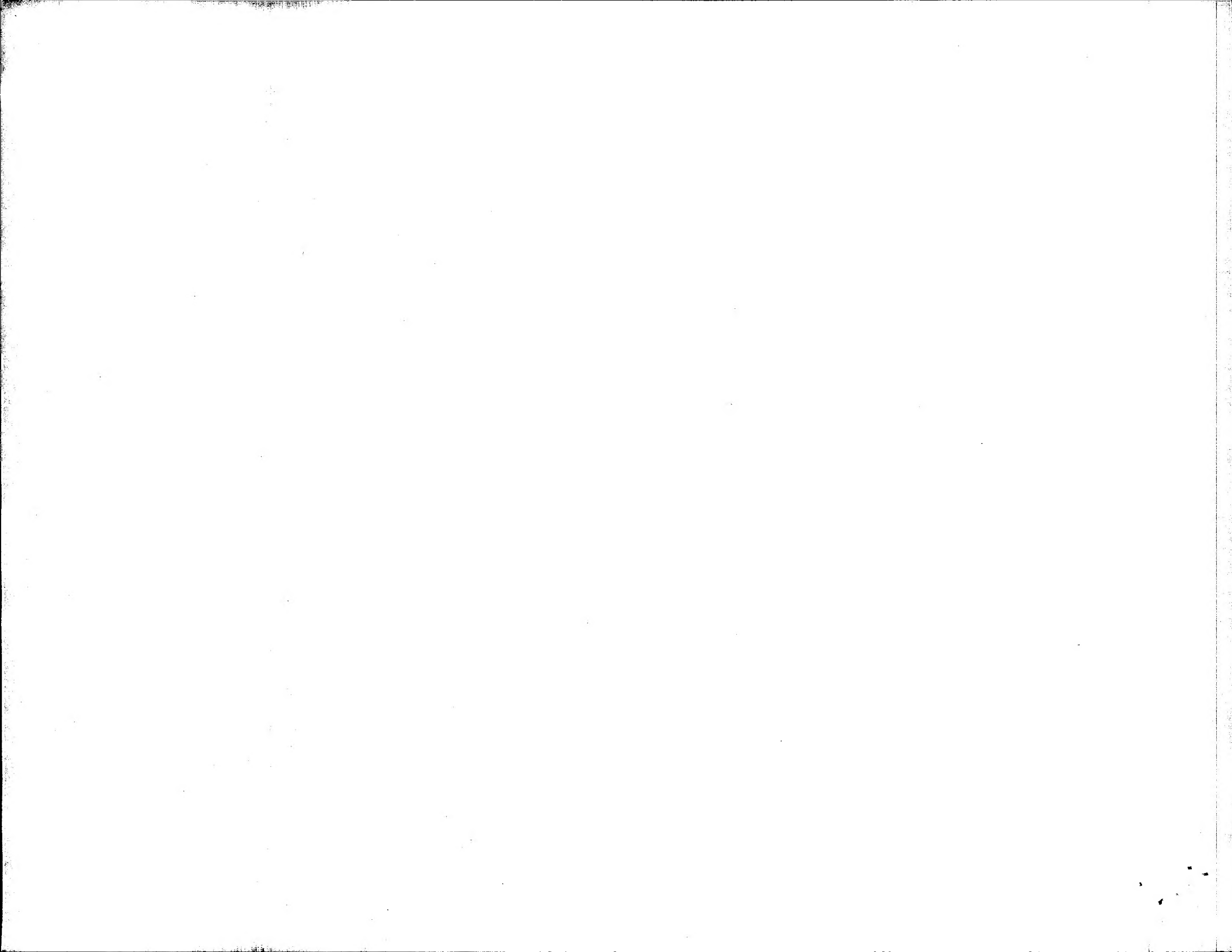
Tel: 613-632-5200 Ext. 240

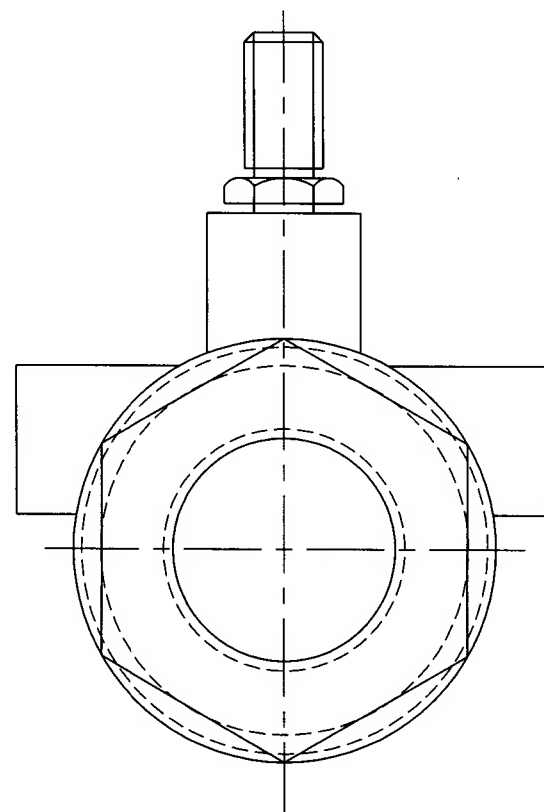
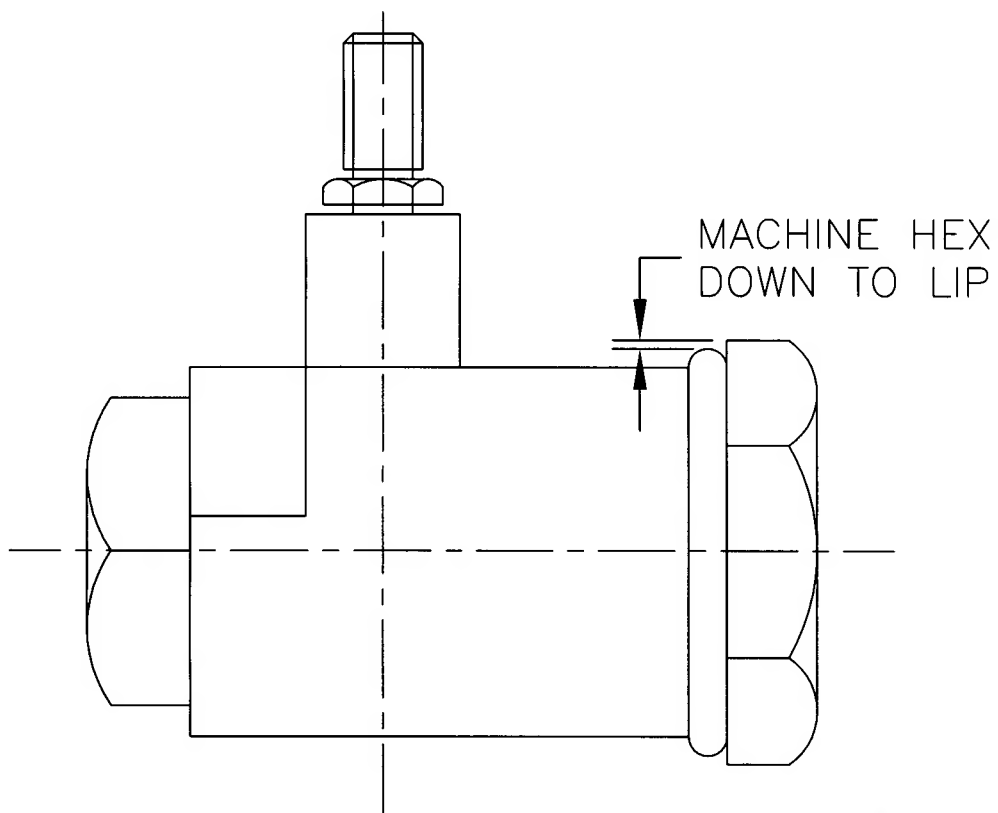
Fax: 613-632-9311

E-mail: [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)

Web: [www.dartaero.com](http://www.dartaero.com)

09/01/2008





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